

Date: Thursday, 6/21/2007 2:29:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 33065		
Estimate Number	: 10440		
P.O. Number	: N/A	Part Number	: D3262041
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D3262 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 32261	Material	: N/A
Written By	: <u>JJ 07.06.22</u>	Due Date	: 7/15/2007
Checked & Approved By	: <u>JJ 07.06.22</u>	Qty:	6 Um: Each
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	33065A	FUEL PURGE CANISTER
Comment: Sub-Component FUEL PURGE CANISTER D3262-1 B <u>28225A</u> (6) <u>BE 07/11/26</u>		
2.0	33065B	FUEL PURGE CANISTER
Comment: Sub-Component FUEL PURGE CANISTER D3262-3 B <u>33065</u> (12) <u>BE 07/11/26</u>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod <u>M106035</u> <u>BE 07/11/26</u>		
4.0	QC5/9	WELD INSPECTION
Comment: WELD INSPECTION Pressure test as per Dwg D3262 <u>QC 5</u> <u>BE 07.11.26</u> (6)		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>M-1</u> <u>07/11/27</u> (6X)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FUEL PURGE CANISTER

Job Number: 33065

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M/05914



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

FL 07/11/27 (6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-P 07/11/27 (6X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

W. 07/11/28 (X6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE .



Comment: FINAL INSPECTION/W/O RELEASE

Don 07/11/08 (6)

Job Completion



U 07/11/28

M/05914

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

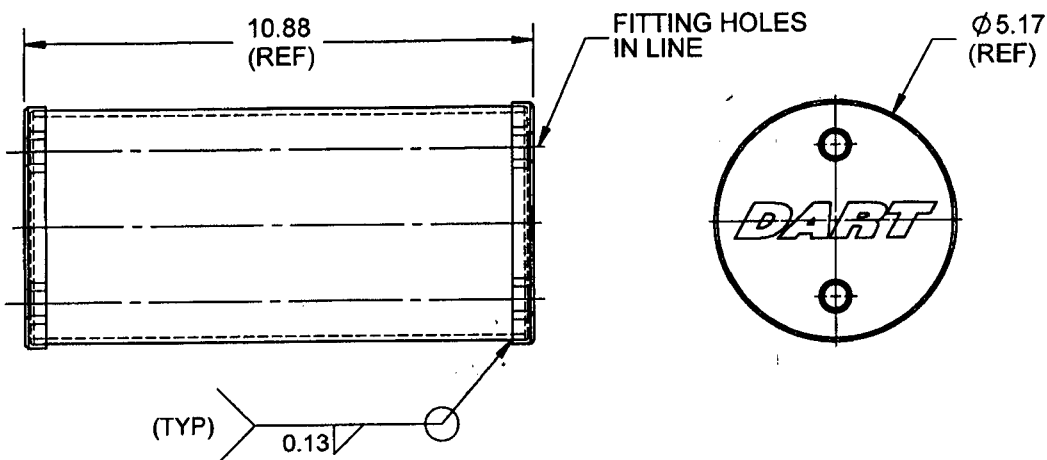
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	


RELEASED
06.09.19 *[Signature]*

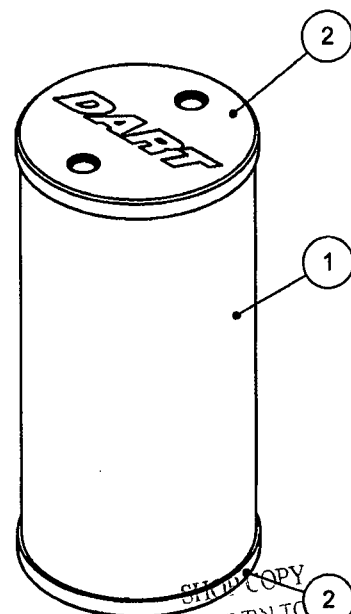


D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS 
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



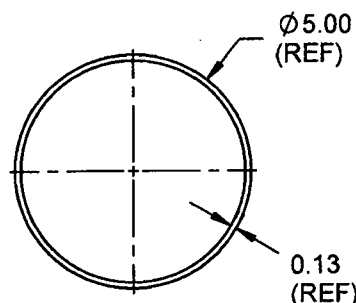
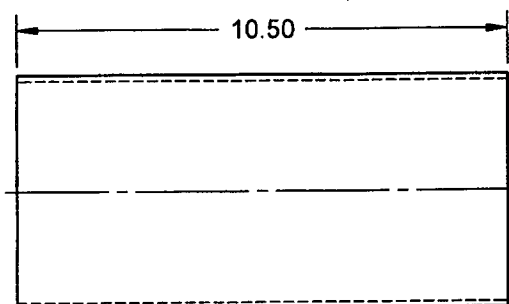
SHUT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33065**

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DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4

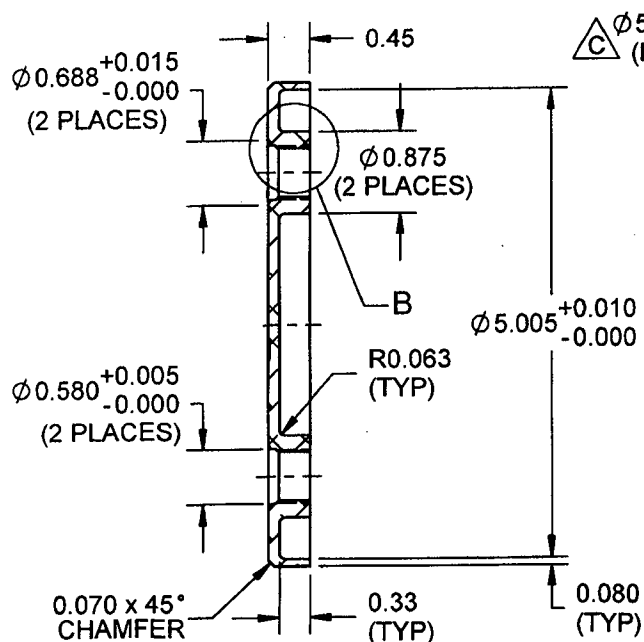


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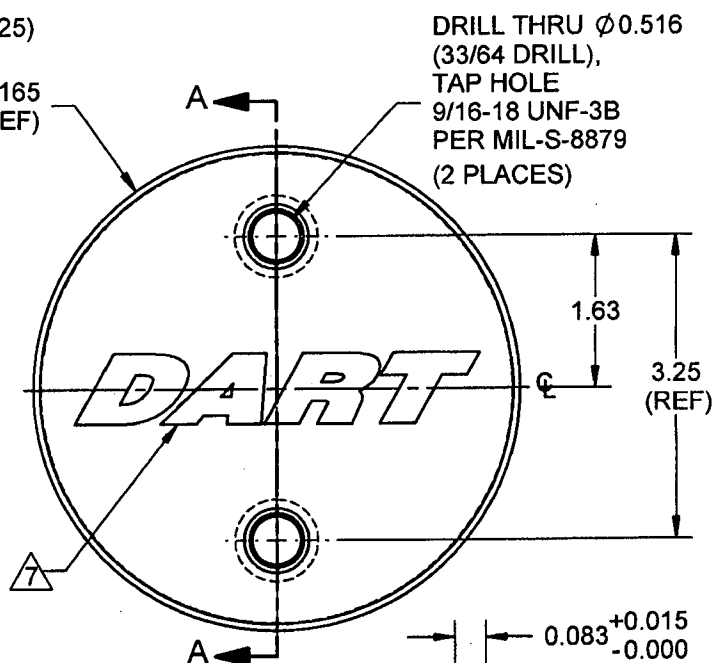
06.09.19

D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2

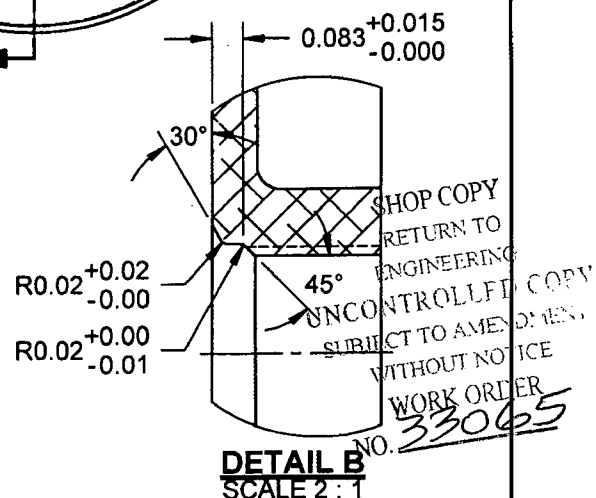


D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



DETAIL B
SCALE 2:1

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